

Work Order ID 78988

\*78988\*

Page 1

January-18-12 8:36:53 AM

Item ID: D2654-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Web

Stop \*NS2\*

Start Date: 18/01/2012 Start Qty: 600

Required Date: 01/02/2012 Req'd Qty: 600

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/18

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

F

100

0.00

\*100\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005.4.1

0.00

\*120\*

HandFinish

Memo

0.00

Hand Finishing

4 SAD 12-03-21

DP 12-3-21

EF 12-3-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78988

**\*78988\***

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January-18-12 8:36:53 AM

Item ID: D2654-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 18/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC3- Inspect Part Finish <i>QC7</i> Memo	0.00  0.00							
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>46</i>  Memo	0.00  0.00							
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*DP 12-3-21 P10*

*DP 12-3-21 (41)*

*12/3/22*

*12-03-21*

W/O: 78988		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-3-21	130	• Should read QC7 Done HJ	D	12-3-21			

Part No: D2654-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

January-18-12 8:36:58 AM

Page 1

Work Order ID: 78988

**\*78988\***

Parent Item: D2654-3

**\*D2654-3\***

Parent Item Name: Web

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured

No

100

Each

232.0000

1

6

**\*D2600-5-108\***

Extrusion 'I Beam' thin

\*\*

SAD

12-03-21

Location

Loc Qty

Loc Code

LG

232

47814

20

73909

212

4

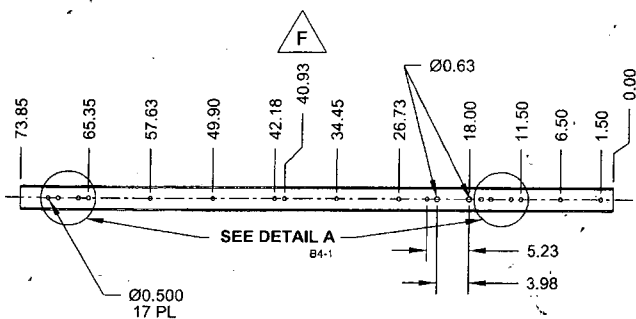
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

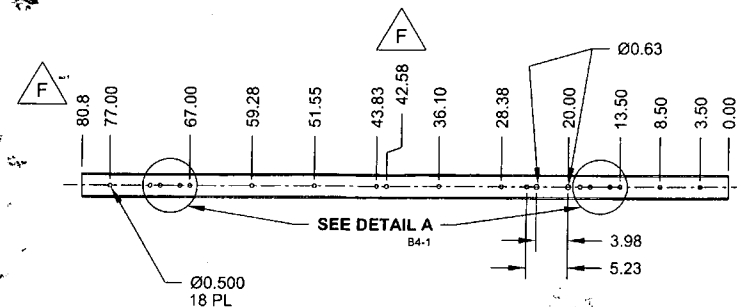
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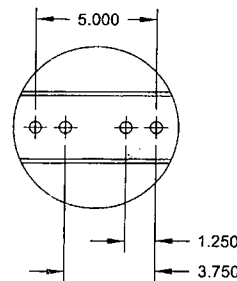
**NOTE:** Date & initial all entries



**D2654-1 WEB**



**D2654-3 WEB**



**DETAIL A**

SHOUL  
REF IN  
ENGINE  
UNCONTROL  
SUBJECT TO  
WITH  
WORK  
NO. 78988 M.C.J.  
12/01/18

RELEASED  
2011-09-12  
W

**NOTES:**

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DESCRIPTION	DATE
DRAWN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	CP	D2654	SHEET 1 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	WEB	NTS
DATE	11.05.05		

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

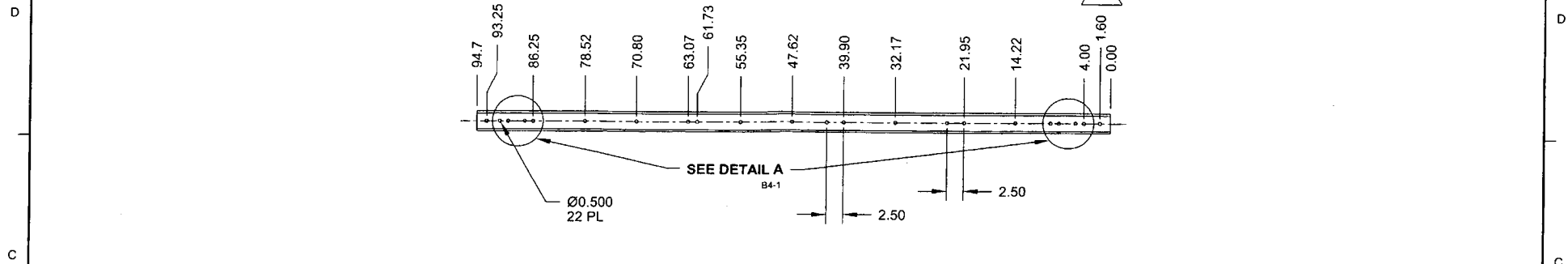
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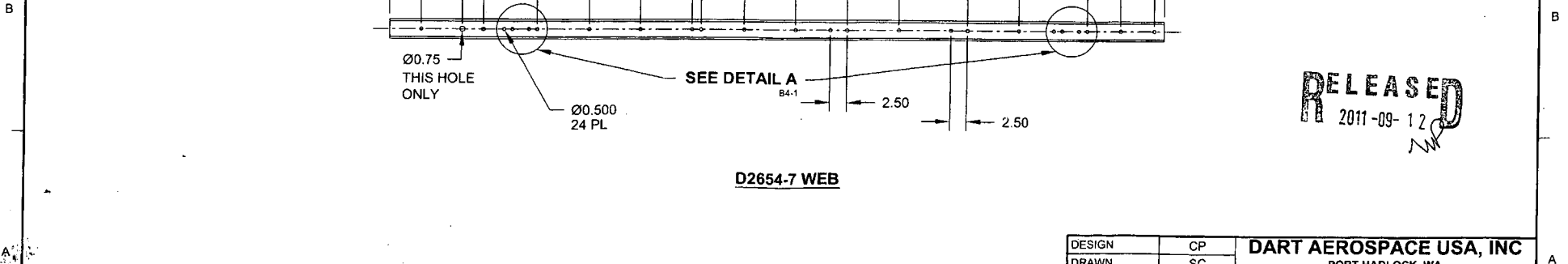
**NOTE:** Date & initial all entries



A horizontal number line with tick marks labeled 1 through 8 from right to left. The line is slightly curved and has a dashed line extending to the right.



**D2654-5 WEB**



**D2654-7 WEB**

RELEASED  
2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	<b>PART HADLOCK, WA</b>	
CHECKED	<i>g</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>E</i>	D2654	SHEET 2 OF 2
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	WEB	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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